

Date: Monday, 08/06/2009 10:22:28 AM
 User: Julie Dawson

Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd.	Drawing Name : DSI9462-011
Job Number : 48394	
Estimate Number : 10804	
P.O. Number :	Part Number : REWORK20 DISASSEMBLE
This Issue : 08/06/2009 S.O. No. :	Drawing Number : R09-061
Prsht Rev. : NC	Project Number :
First Issue : // Type : SMALL /MED FAB	Drawing Revision :
Previous Run : 00015	Material :
Written By :	Due Date : 15/06/2009 Qty: 4 Um: Each
Checked & Approved By : <u>Julie Dawson 08/06/09</u>	
Comment :	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D3136043	Window Assembly
-----	----------	-----------------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)
 Window Assembly
 Original B45168 ✓ MF 9/6/8 SP

2.0	D32241	Frame
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)
 Frame
 Original B47759 ✓ MF 9/6/8 SP

3.0	D323710980	Seal
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)
 Seal
 Original B43183 4x 9/6/8 See Step. 8 SP

4.0	D35611	Seal Insert Tool
-----	--------	------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)
 Seal Insert Tool
 Original B45778 ✓ MF 4x 9/6/8 SP

5.0	AN5261032R9	Screw
-----	-------------	-------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)
 Screw
 Original M110584 48x ✓ MF 9/6/8 SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 08/06/2009 10:22:28 AM
Ser: Julie Dawson

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: DSI9462-011

Job Number: 48394

Part Number: REWORK20

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	AN960JD10L	Washer
-----	------------	--------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
Washer
Original M109632

48x

MF 9/6/10

SD

7.0	MS21042L3	Nut
-----	-----------	-----



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
Nut
Original M110844

48x

MF 9/6/10

SD

8.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

All items are in good condition, BUT the D3237-3-098 filler seal was not returned with the kit

05-06-08 (P)

Adjust

9.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Identify the parts with the part # and keep the original batch #
Return to stock

Location: _____

Adjust
Accpac
M.F 09-06-10

10.0	QC21	FINAL INSPECTION/W/O RELEASE
------	------	------------------------------



Comment: FINAL INSPECTION/W/O RELEASE

09/06/10

Job Completion



MF
09-06-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 06/05/2009 2:10:32 PM
 User: Melanie Fauteux

Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd. Drawing Name : WINDOW SUBSTITUTION KIT
 Job Number : 47766
 Estimate Number : 10804
 P.O. Number :
 This Issue : 06/05/2009 S.O. No. :
 Prsht Rev. : NC
 First Issue : / / Type :
 Previous Run : 00015
 Written By :
 Checked & Approved By : MF 09-05-06
 Comment :

Part Number : DSI 9462011
 Drawing Number : DSI 9462011 *PRELIM A*
 Project Number :
 Drawing Revision :
 Material :
 Due Date : 06/05/2009 Qty: 4 Um: Each

REFERENCE ONLY

Additional Product

PRELIMINARY ISSUE *09.05.06*

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

CH7001



Page work set by E-mail

09/05/06

2.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1



3.0 D3136043 Window Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)
 Window Assembly

B 45168



09/05/06 (4)

4.0 D32241 Frame



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)
 Frame

44164 47759



09/05/06 (4)

5.0 D323710860 Seal



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)
 Seal

43140 43183



09/05/06 (4)

6.0 D323730480 Seal Filler



Comment: Qty.: 1.0000 f(s)/Unit Total: 4.0000 f(s)
 Seal Filler

Not in kit



09/05/06 (4)

Date: Wednesday, 06/05/2009 2:10:32 PM
User: Melanie Fauteux

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: WINDOW SUBSTITUTION KIT

Job Number: 47766

Part Number: DSI 9462011

Job Number:



Seq. #:

Machine Or Operation:

Description:

7.0

D35611

Seal Insert Tool



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)
Seal Insert Tool

BL5778

SS 09/05/06

8.0

AN5261032R9

Screw



Comment: Qty.: 12.0000 Each(s)/Unit Total: 48.0000 Each(s)
Screw

110584

SS 09/05/06

9.0

AN960JD10L

Washer



Comment: Qty.: 12.0000 Each(s)/Unit Total: 48.0000 Each(s)
Washer

M69632

SS 09/05/06

10.0

MS21042L3

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total: 48.0000 Each(s)
Nut

M110844

SS 09/05/06

11.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

ENGINEERING
APPROVAL

09/05/06

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/05/13

Job Completion



POSITIVE RECALL

EFFECTIVE

RELEASED

DATE

09-05-06

09-05-06

MF

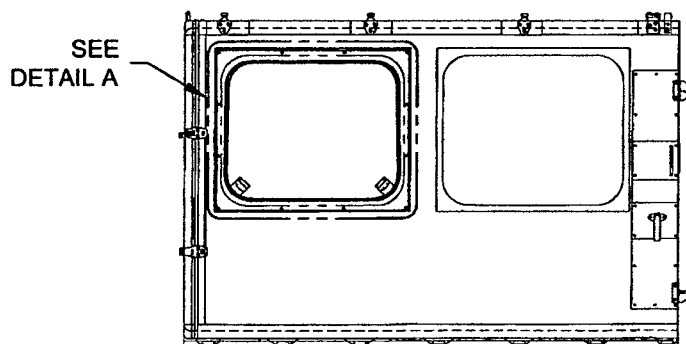
(continued from Sheet 1)

- 1.2.8 Apply 0.010 to 0.015 inches of RTV-732 sealant to both sides of the narrow seal insert groove (see Figure 2).
- 1.2.9 Apply 0.010 to 0.015 inches of RTV-732 sealant to areas of the window frame that have been prepared for bonding with Dow 1200 primer per 3.2.5.
- NOTE:** It is prohibited to bond lower corners as shown in Figure 2.
- 1.2.10 Do not put any adhesive in the seal groove that accepts the window. Note that the seal insert groove faces outboard (see Figure 2).
- 1.2.11 Install D3237-1-0980 seal in the frame. Trim as required. Masking tape may be used temporarily to hold the seal in place for the next step.
- 1.2.12 Place the window in the seal groove and work seal lip around the periphery of the window.
- 1.2.13 Install D3237-3-0980 into D3237-1-0980 using D3561-1 Window Seal Tool (or equivalent). Trim seal as required. Work the seal insert around until it fits properly.
- 1.2.14 Remove all masking tape and allow sealant to cure for a minimum of 24 hours at 75°F (24°C).
- 1.2.15 Each modified emergency exit should be marked. Paint a contrasting color band 2.0" wide per FAR 29.811 (see Figure 2) if it has not already been done.

2.0 PARTS LIST

Qty -011	Part No.	Description
X	DSI 9462-011	WINDOW SUBSTITUTION KIT
1	D3136-043	WINDOW ASSEMBLY
1	D3224-043	FRAME
1	D3237-1-0980	SEAL RETAINER
1	D3237-3	SEAL FILLER
1	D3561-1	WINDOW SEAL TOOL
12	AN5261032R9	SCREW
12	AN960JD10L	WASHER
12	MS21042L3	NUT (OR MS21042-3)

4X



PRELIMINARY ISSUE

09.05.06

REFERENCE ONLY

**FIGURE 1: D412-694-01 DOOR ASSY (SHOWN)
D412-694-02 DOOR ASSY (OPPOSITE)
VIEW LOOKING OUTBOARD, NOT TO SCALE**

47766

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: D. SHEPHERD (DE # 02)

DATE: 09.05.06

CERT. NO.: SH05-10

ISSUE NO.: 1

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9462	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		WINDOW SUBSTITUTION	NTS
DATE	09.05.06	COPYRIGHT © 2009 BY DART AEROSPACE LTD	
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